

**Work Order ID 63209**

Page 1

Monday, October 25, 2010 12:33:54 PM

Item ID: D212-725-1-191

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D212-725-1

F

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

2024 .063

1-Cut as per Dwg

Dwg Rev: F

Prog Rev: F

2-Deburr if necessary

B10-10-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/27

(x4)

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=&gt; W 10/10/27

x4

Ø

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-10-27

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 63209**

Page 3

Monday, October 25, 2010 12:33:54 PM

Item ID: D212-725-1-191

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 10/25/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/29/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: 384

0.00



Packaging

Memo

0.00

Packaging

\_\_\_\_\_ Perp/28 (4)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

\_\_\_\_\_ 10/10/28 MF

10-10-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, October 25, 2010 12:33:57 PM

Page 1

Work Order ID: 63209



Parent Item: D212-725-1-191



Parent Item Name: Shim

Start Date: 10/25/2010

Required Date: 10/29/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 10.07.19 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

89.0000

0.0156

0.065684



1310-10-27

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT22

89

113866

8.5

114351

80.5

113866

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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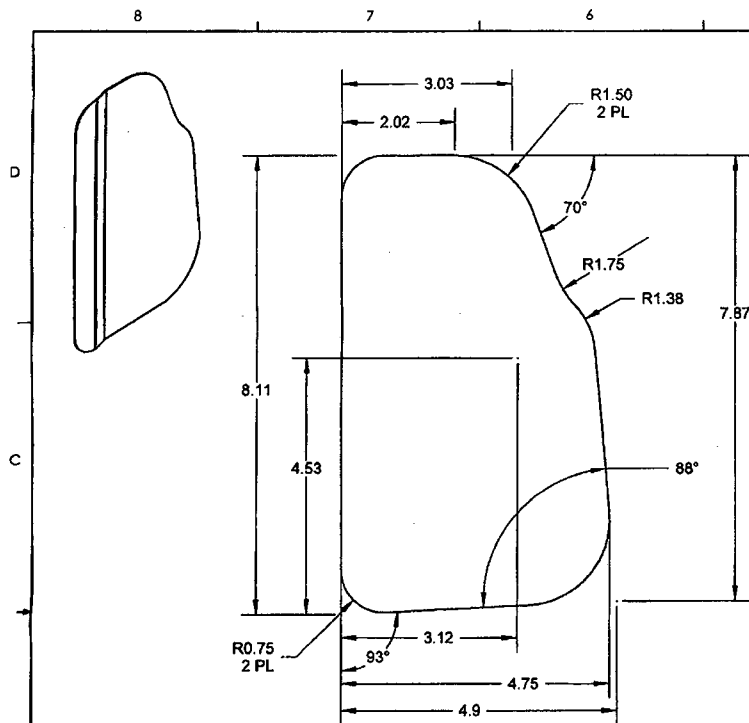
D212-725-1-191

☒ **First Article**     ☐ **Prototype**

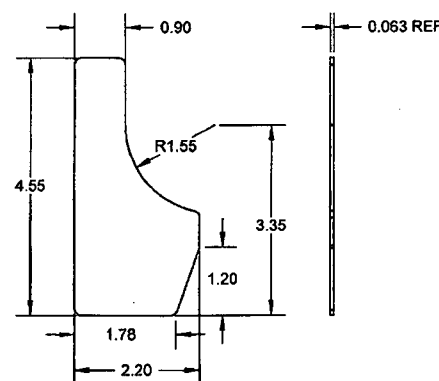
Measured by:	RB	Audited by:	S	Prototype Approval:	N/A
Date:	10-10-27	Date:	10/10/27	Date:	N/A

H:\FORMS\Quality Assurance\approved QA\FAI revD

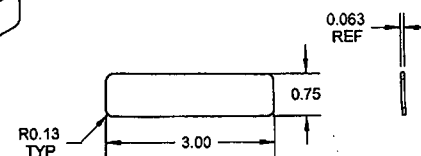
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RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 63209  
R90-10-25



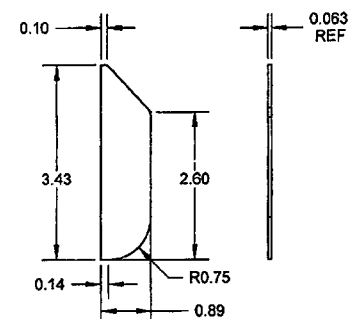
**D212-725-1-177F FLAT PATTERN**



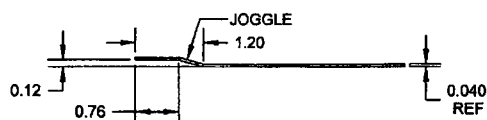
**D212-725-1-187 PACKER**



**D212-725-1-191 SHIM**



**D212-725-1-189 FILLER**



**D212-725-1-177 COVER SHOWN  
D212-725-1-178 OPPOSITE  
(MAKE FROM D212-725-1-177F)**

**D212-725-1-177-178 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

**D212-725-1-187-189-191 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET 0.063 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME PER AIRCRAFT MAINTENANCE MANUAL UPON INSTALLATION
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A

**RELEASED**  
09/24/07

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. F
MFG. APPR.		<b>D212-725-1</b>	SHEET 60 OF 84
APPROVED		TITLE	SCALE
DE APPR.		<b>212S DETAIL PARTS</b>	NTS
DATE	09.02.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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